

Work Order ID 55332

January 13, 2010 10:25:06 AM



Page 1

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 1/13/10 Start Qty: 10.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: RL Date: 10-1-13 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D [I]Prog

Rev: D ☐ 2-Deburr if necessary

10-1-18



110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-1-18

120 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

10-1-18



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date:

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT8179

SB 10/01/19

12 0

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

=> 5/10/19

(412)

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch U/A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

11/3521

107-20 (X12)

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ 8/10/12/1

412

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8/10/12/1

412

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

1112588

0.00

⇒ 10/02/10

412

Powdercoat

Memo

START TIME: 1:00pm OVEN TEMPERATURE:

1:30pm FINISH TIME: 320°

Powder Coating

W/O:		WORK ORDER CHANGES					
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Page 4

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

BL 16-02-11



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: FP-19

0.00

10/02/10

X12



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

10/02/11



QC

Memo

0.00

Quality Control

ME 10-2-11

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:25:10 AM

Page 1
1

Work Order ID: 55332



Parent Item: D3564-11



Parent Item Name: Wearshoe

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Start Qty: 10.00

Required Qty: 10.00

M304S16GA

Purchased No

100 sf

318.2779 14.8421

18,



B/C-1-18

304/316 Sheet .063

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

318.2778737

106860

8.0295

111924

25.1689737

112442

29.8899

113295

255.1895

113295

12

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	55332
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.222	✓			
2.432	+/-0.010	2.436	✗			
2.50	+/-0.030	2.50	✗			
6.000	+/-0.010	6.000	✗			
12.104	+/-0.010	12.104	✓			
18.000	+/-0.010	18.000	✓			
18.00	+/-0.030	18.00	✗			
9.00	+/-0.030	9.00	✗			
11.50	+/-0.030	11.50	✗			
0.300 x 0.300	+/-0.010	.303 x .303	✗			
Ø0.188	+0.005/-0.001	.190	✗			
R0.375	+/-0.010	.375	✗			
0.063	+/-0.010	.061	✗			

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-13	Date:	10/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

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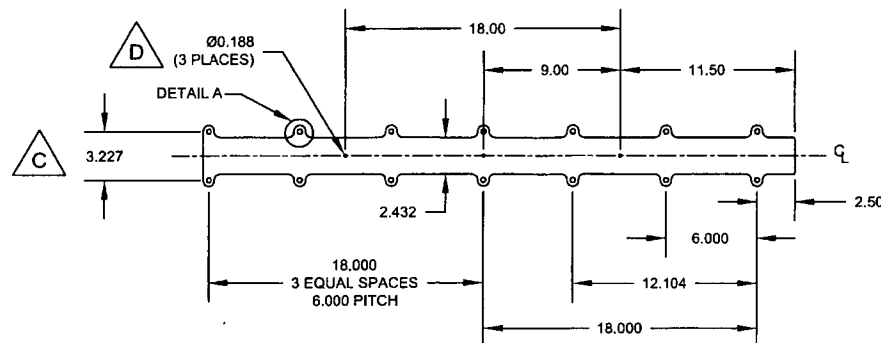
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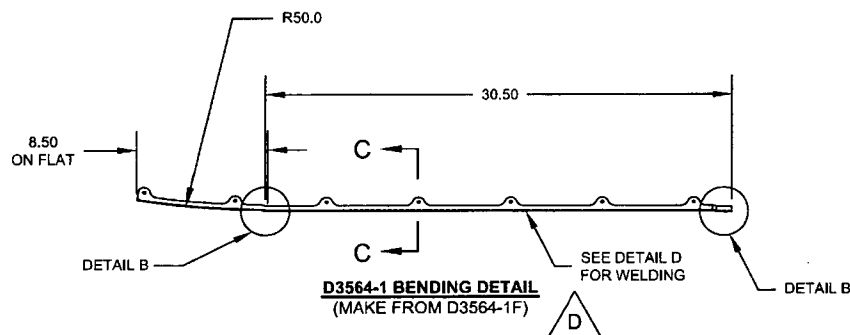
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55332
BP 10-1-12

RELEASED

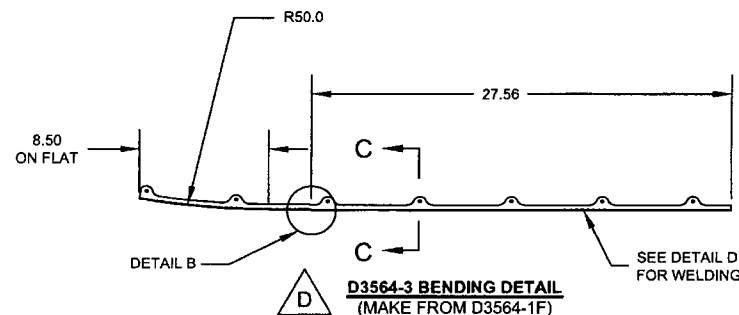
07.09.04 h



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT \bar{C}

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 REV. D SHEET 1 OF 3 TITLE WEARSHOE SCALE 1:8	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21	<small> COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

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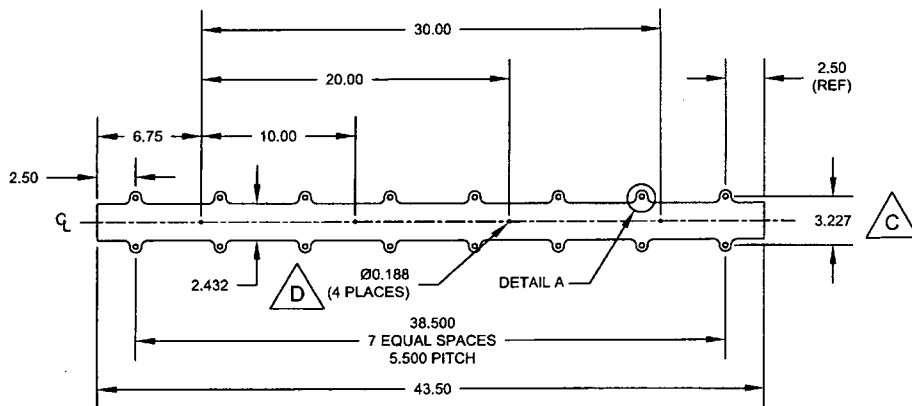
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

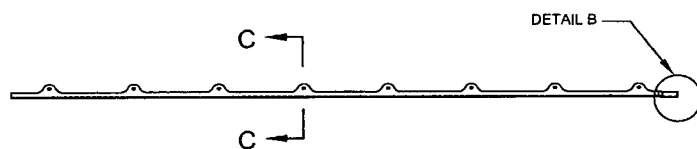
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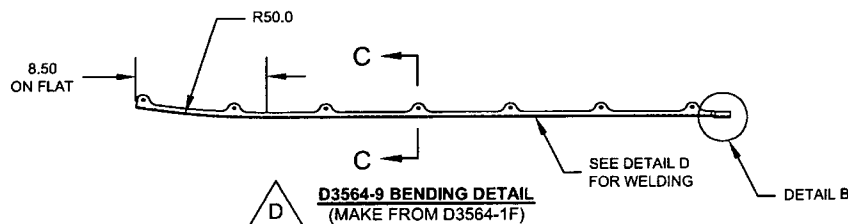
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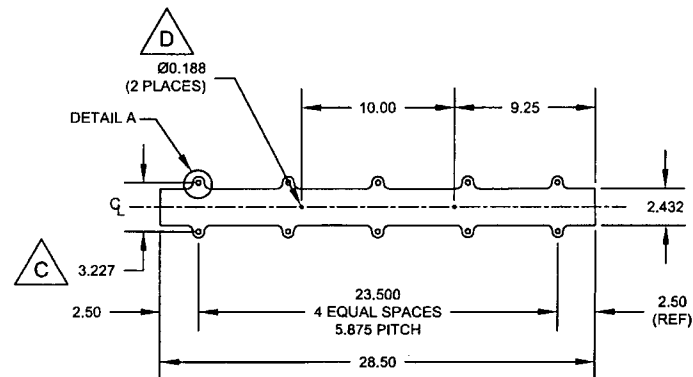
D3564-5F FLAT PATTERN



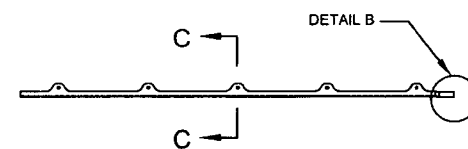
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



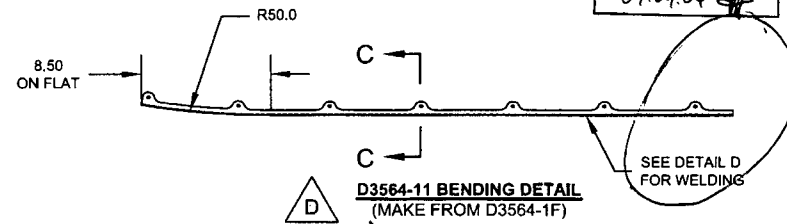
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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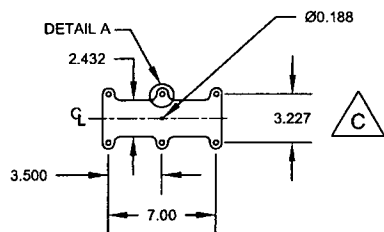
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

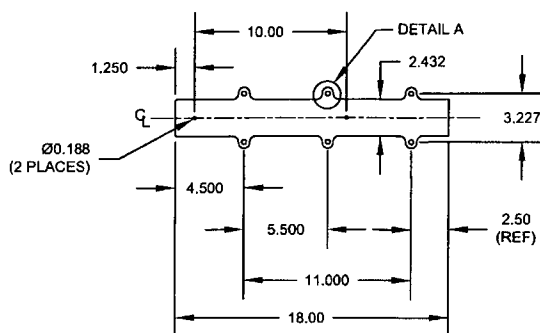
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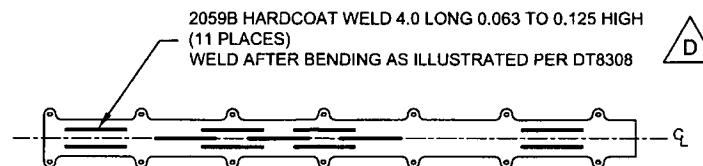
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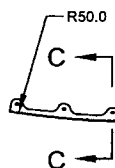
D3564-13F FLAT PATTERN



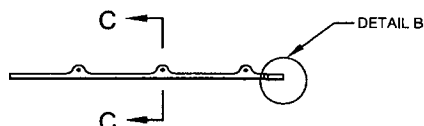
D3564-15F FLAT PATTERN



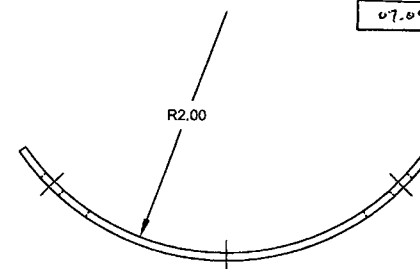
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



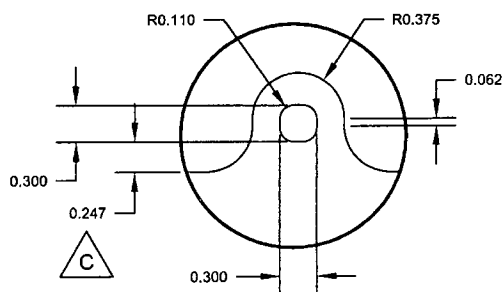
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



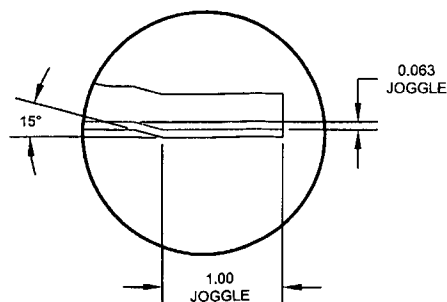
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

RELEASED

07.09.04

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DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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APPROVED	PH	TITLE	SCALE
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W/O 55332

8 7 6 5 4 3 2 1

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